














Date: Thursday, 18/09/2008 11:14:08 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BASE
Job Number	: 42118		
Estimate Number	: 13033		
P.O. Number	:	Part Number	: D36519
This Issue	: 18/09/2008 S.O. No. :	Drawing Number	: D3651 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 39937	Material	:
Written By	:	Due Date	: 25/09/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>JUL 18.9.18</u>		
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S26GA	304/316 0.018 SHEET	
			
Comment: Qty.: 0.4526 sf(s)/Unit Total: 2.2628 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: <u>109390 HB 8-9-29</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3651 Dwg Rev: <u>B</u> <u>HB 8-9-29</u>  Prog Rev: <u>B</u> 2-Deburr if necessary <u>HB 8-9-29</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-9-29</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>808108/29 CS</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		 	
Comment: PACKAGING RESOURCE #1 Identify and stock Location: <u>176</u> <u>8/9/29</u> <u>SD</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:14:08 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 42118

Part Number: D36519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 *HL*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42118
Description: Inside Doubler		Part Number: D3651-9
Inspection Dwg: D3651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.004/-0.001	.254	X			
0.250	+/-0.010	.251	X			
0.500	+/-0.010	.502	X			
6.33	+/-0.030	6.333	X			
9.81	+/-0.030	9.81	X			
2.818	+/-0.010	2.819	X			
2.100	+/-0.010	2.100	X			
2.100	+/-0.010	2.100	X			
2.575	+/-0.010	2.576	X			
2.000	+/-0.010	1.999	X			
5.514	+/-0.010	5.520	X			
2.750	+/-0.010	2.744	X			
2.200	+/-0.010	2.195	X			
2.371	+/-0.010	2.376	X			
1.325	+/-0.010	1.320	X			
3.112	+/-0.010	3.116	X			
1.400	+/-0.010	1.399	X			
5.514	+/-0.010	5.517	X			

Measured by: LB	Audited by: S	Prototype Approval:	N/A
Date: 8-9-29	Date: 08/09/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

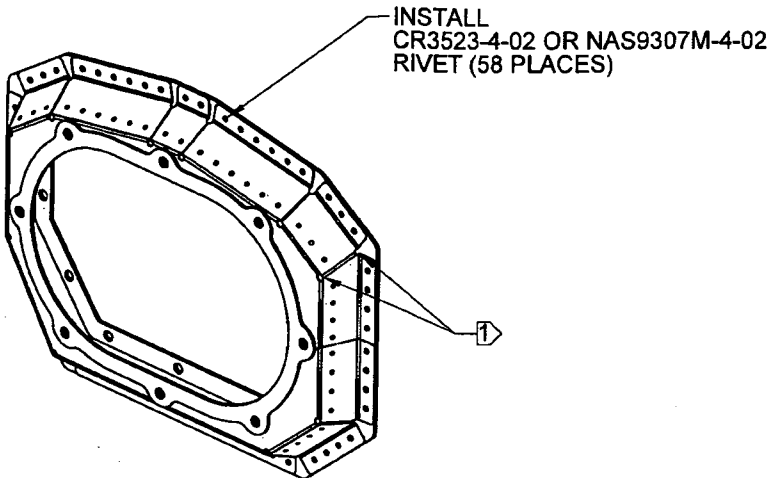
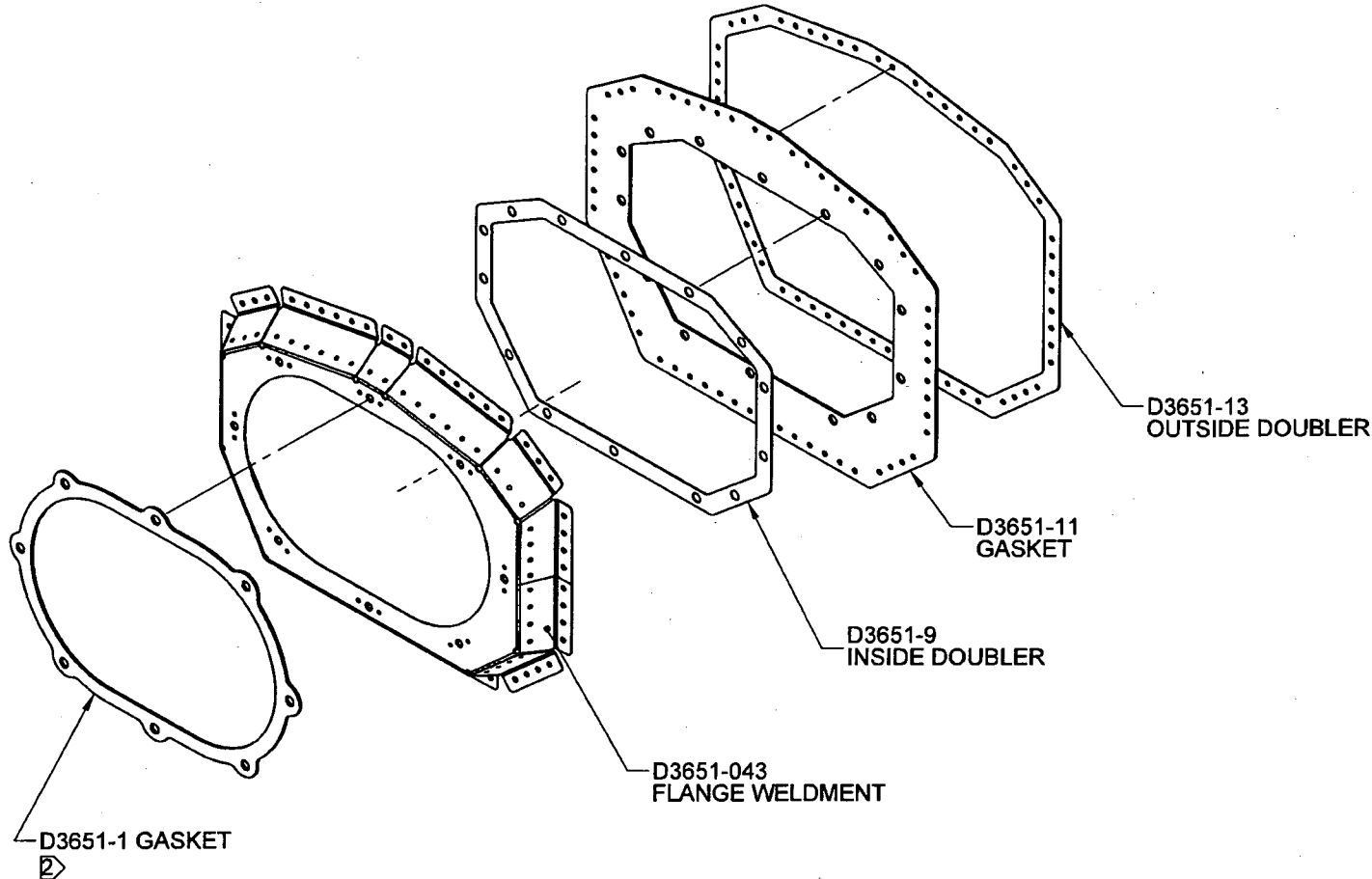
8 7 6 5 4 3 2 1

D

C

B

A



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

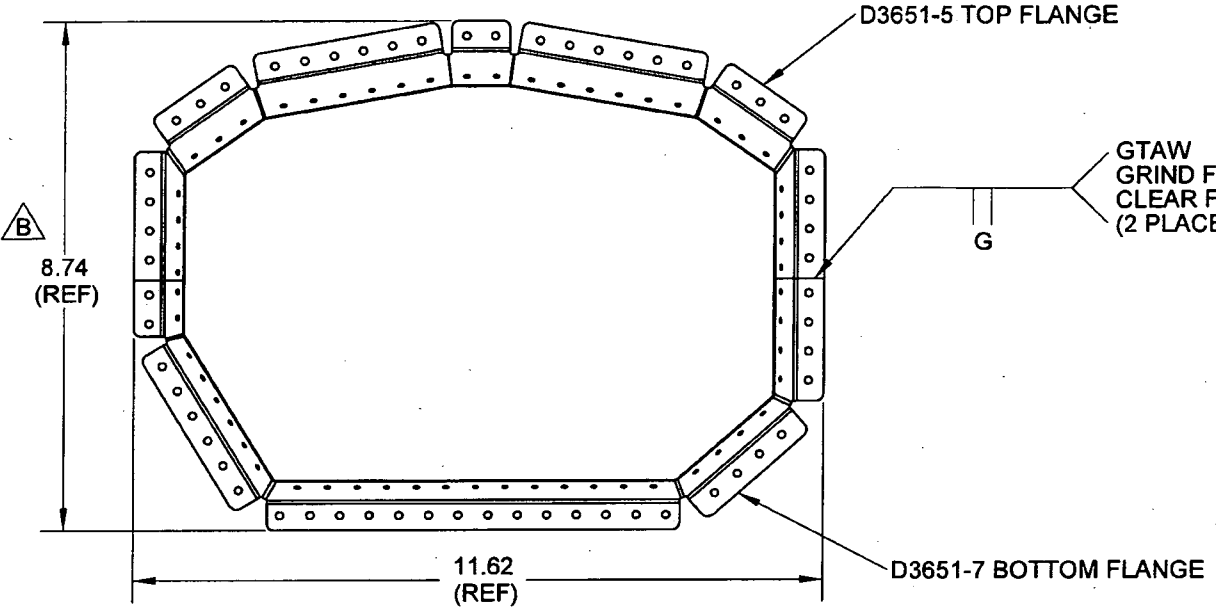
RELEASED
08-03-27/11P

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:4
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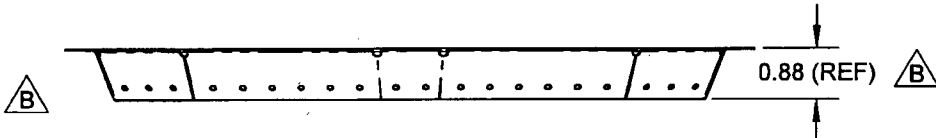
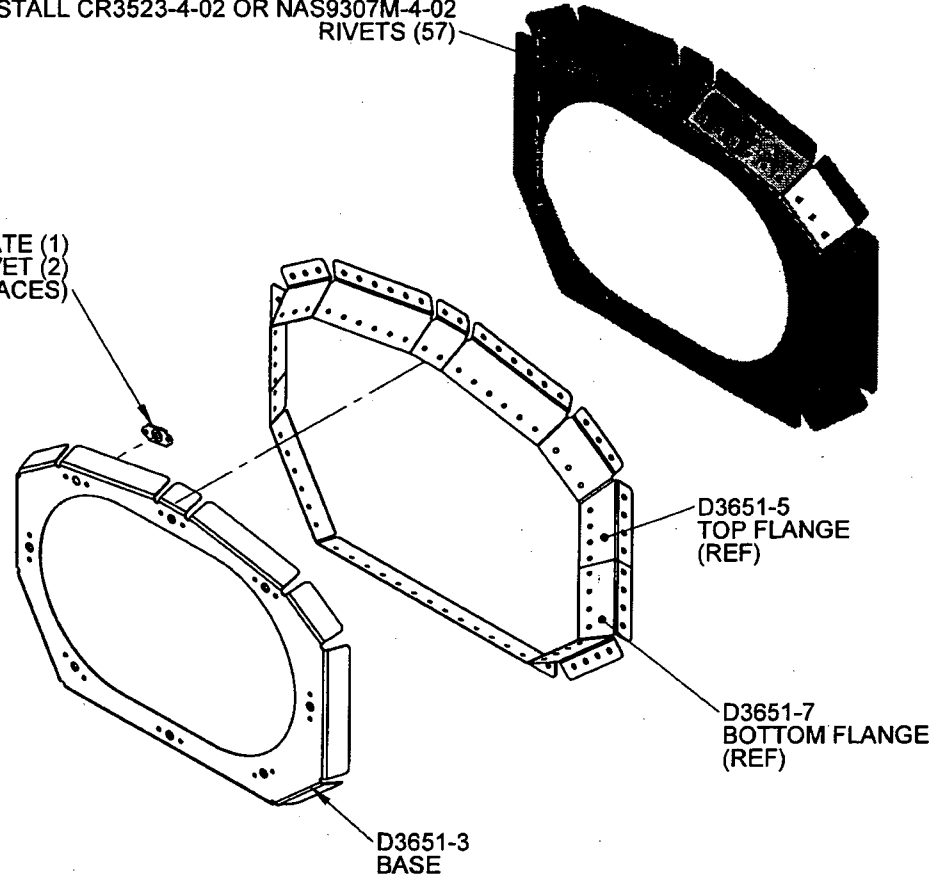
WORK ORDER
NO 4218

8 7 6 5 4 3 2 1

TRANSFER DRILL $\phi 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



D3651-043 FLANGE WELDMENT

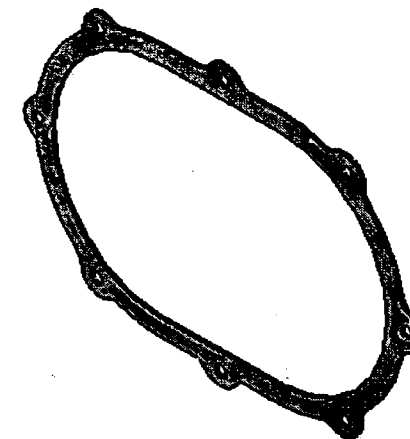
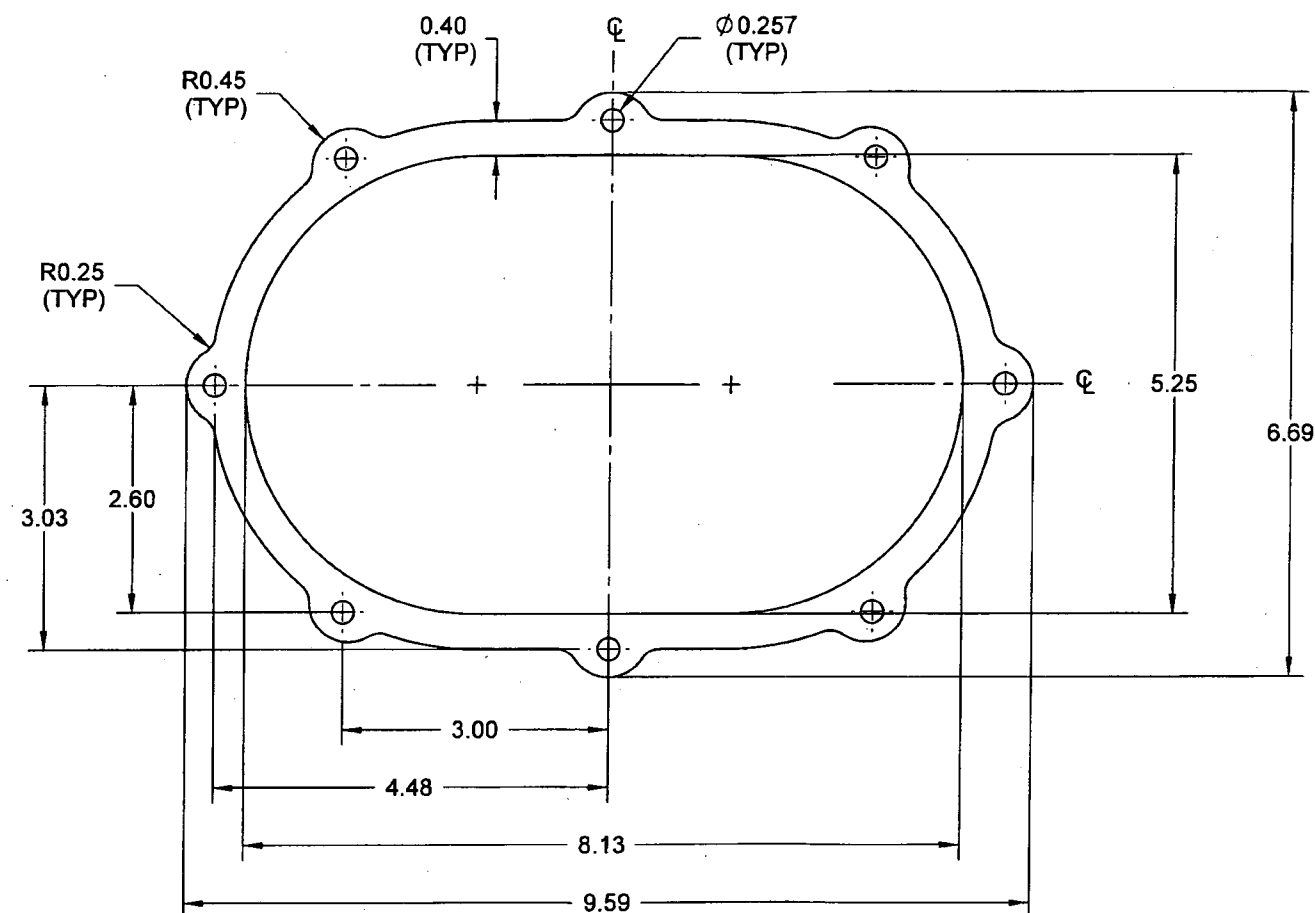
QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

- D3651-043 NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.76 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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CHECKED	LE	DRAWING NO. D3651
MFG. APPR.	MA	REV. B
APPROVED	RF	SHEET 2 OF 9
DE APPR.	RF	TITLE AFT BASE ASSEMBLY
DATE	08.01.07	SCALE 1:3

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




D3651-1 GASKET

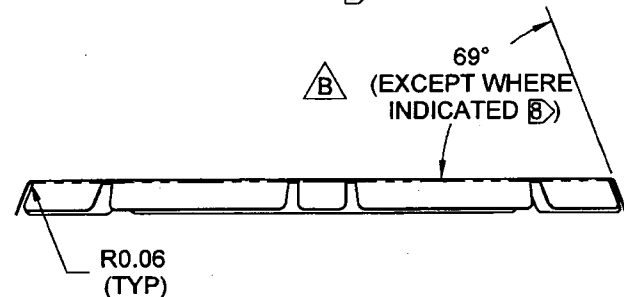
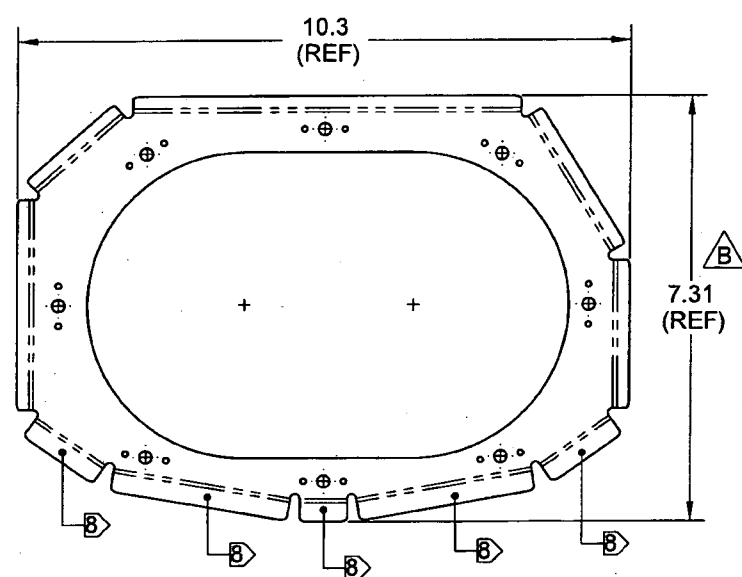
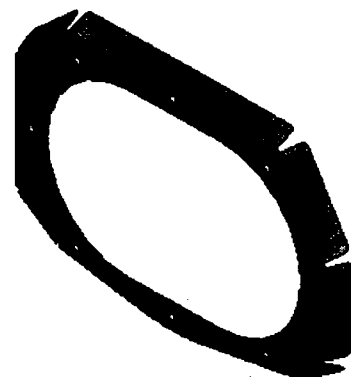
NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT CL
- 8) WEIGHT: 0.09 lbs

RELEASED
08-03-27

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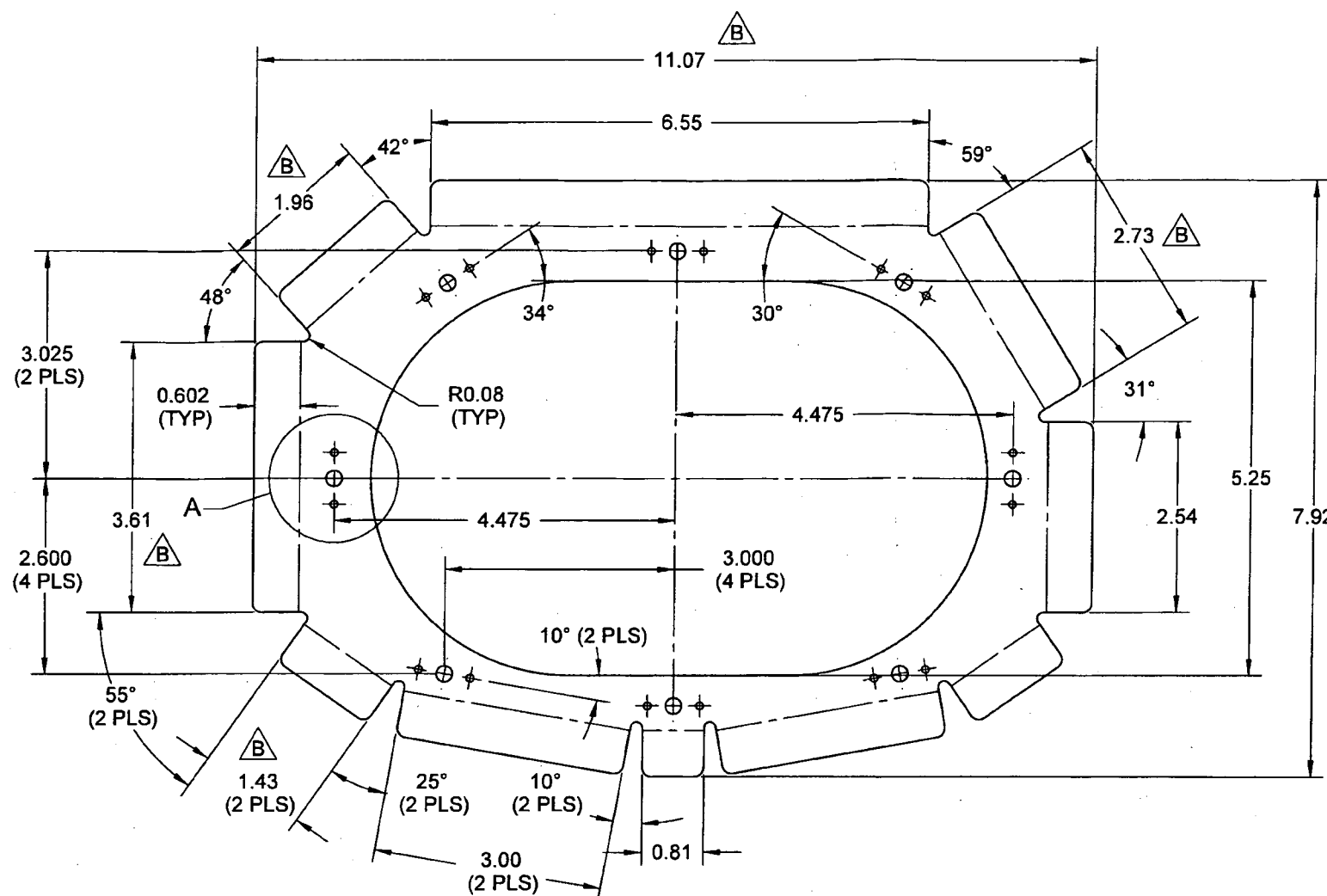
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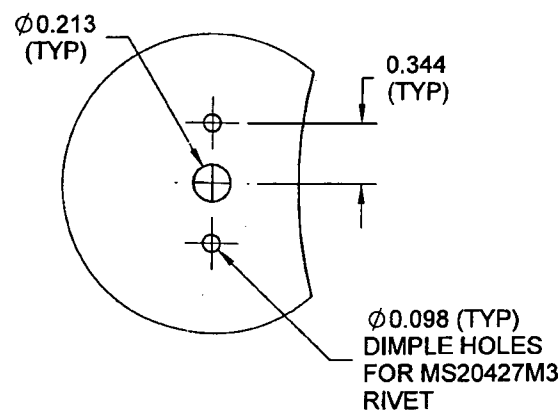
D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



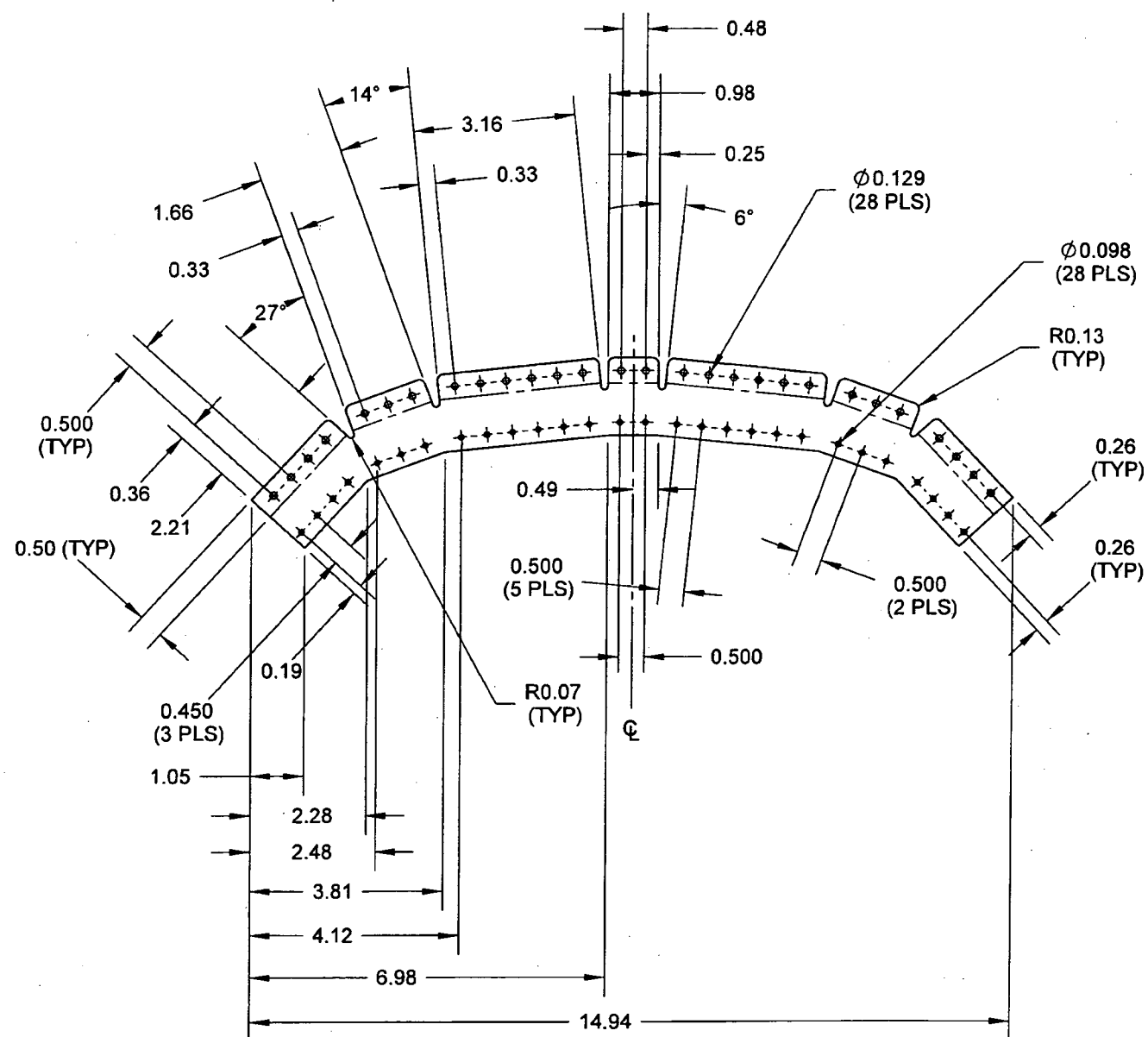
D3651-3F FLAT PATTERN



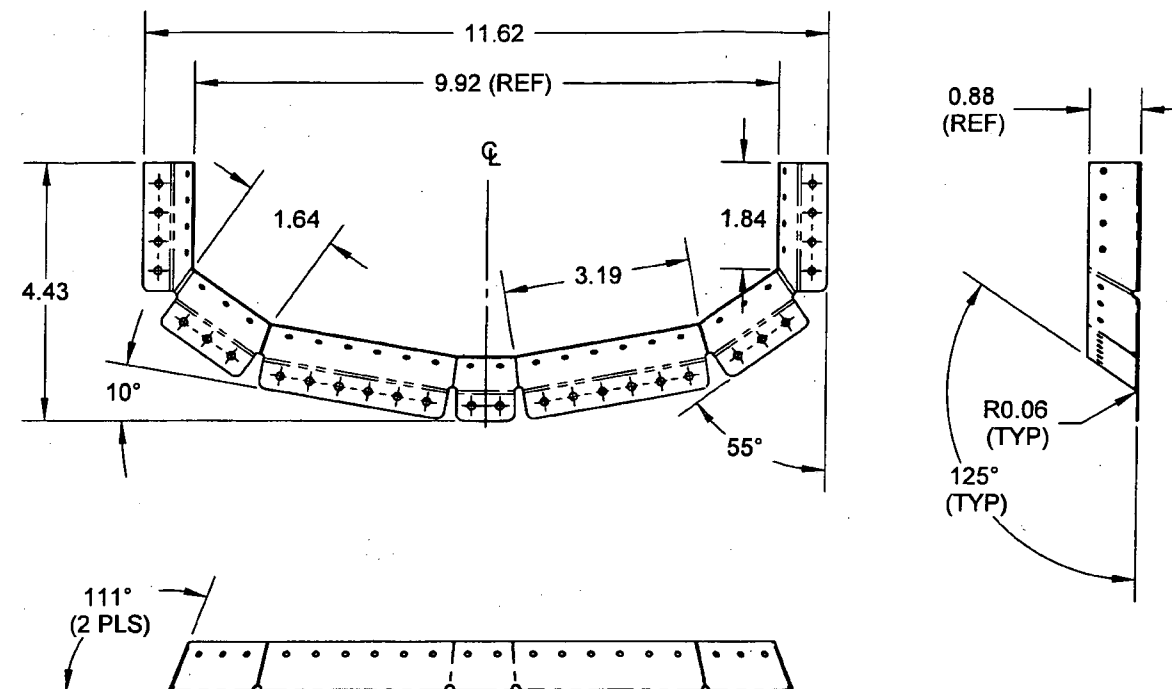
DETAIL A

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MFG. APPR.	MA	D3651	SHEET 4 OF 9
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
D3651-5F FLAT PATTERN



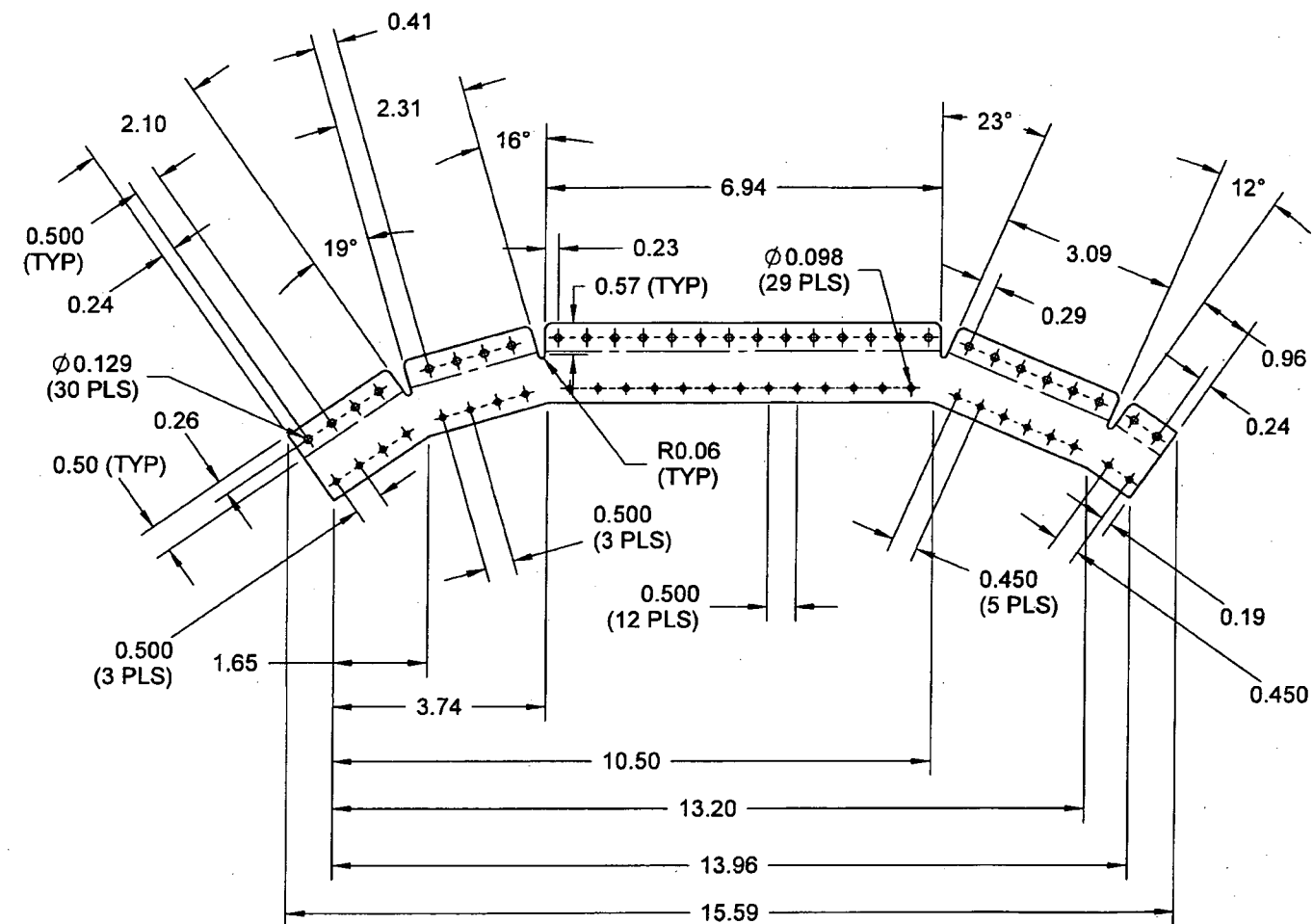
D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

NOTES:

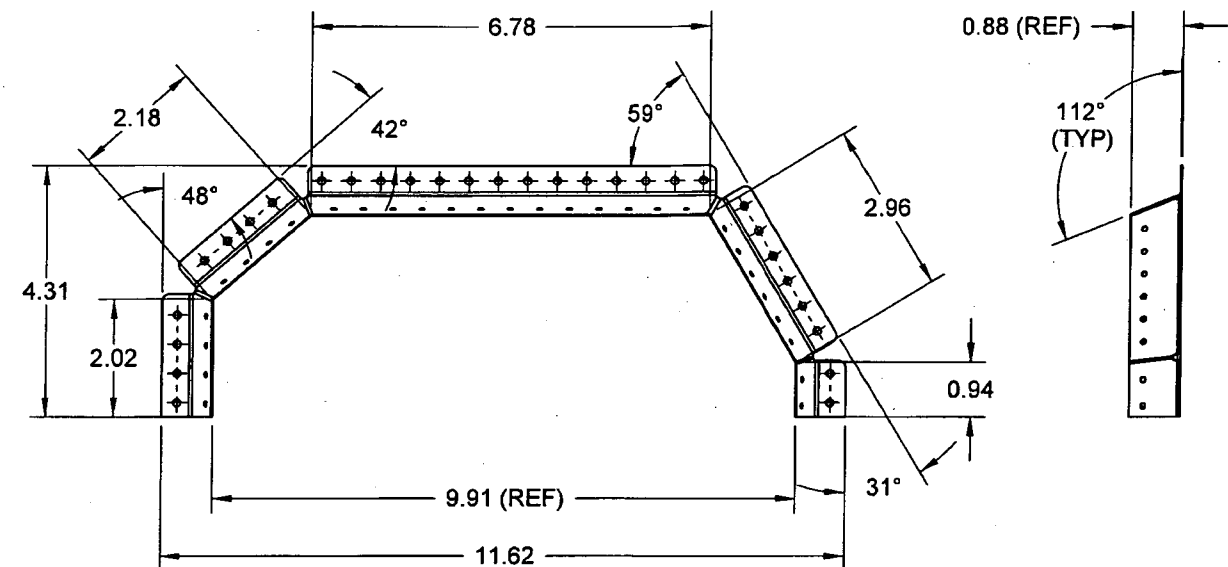
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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MFG. APPR.		D3651	SHEET 5 OF 9
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D3651-7F FLAT PATTERN



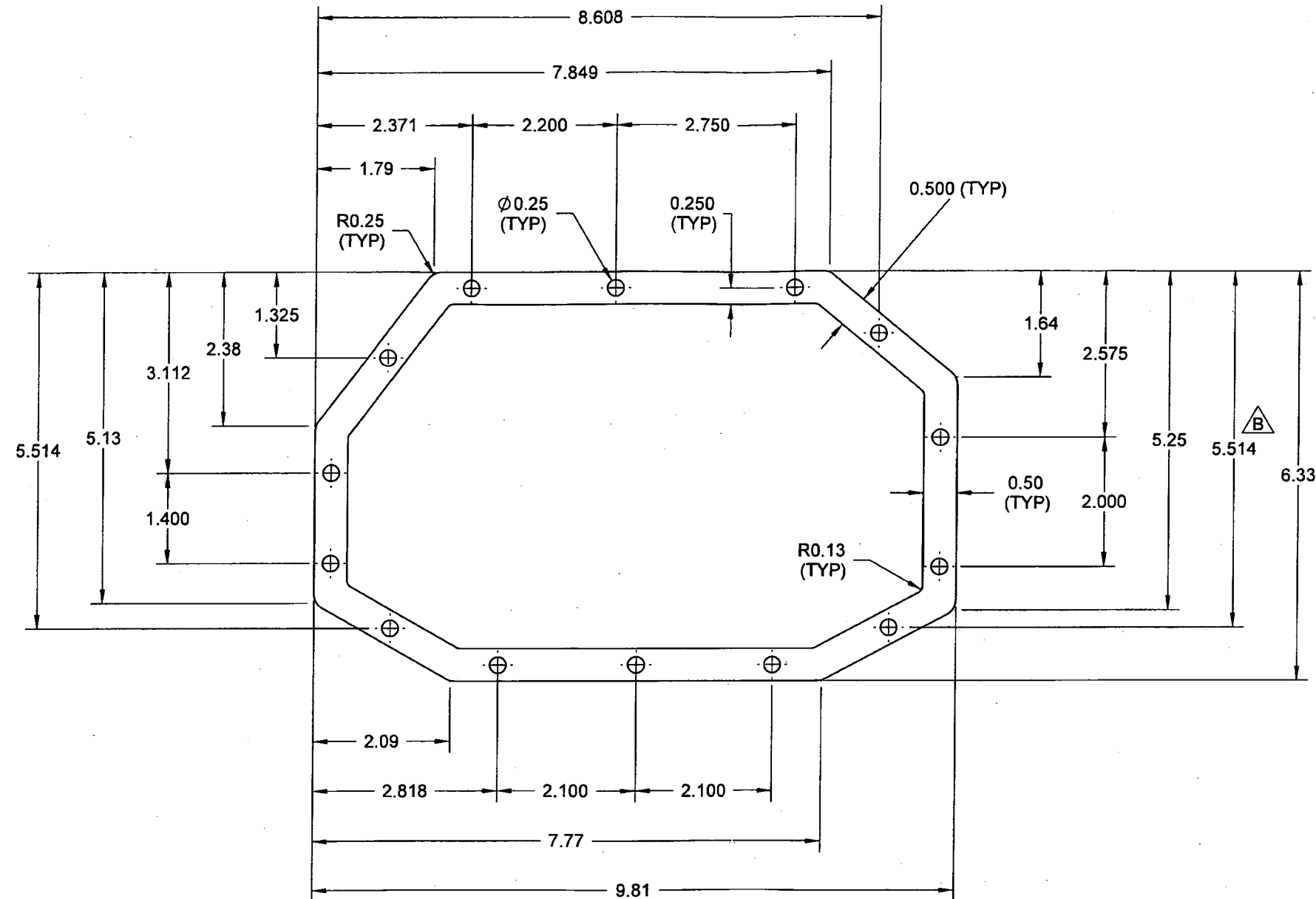
D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
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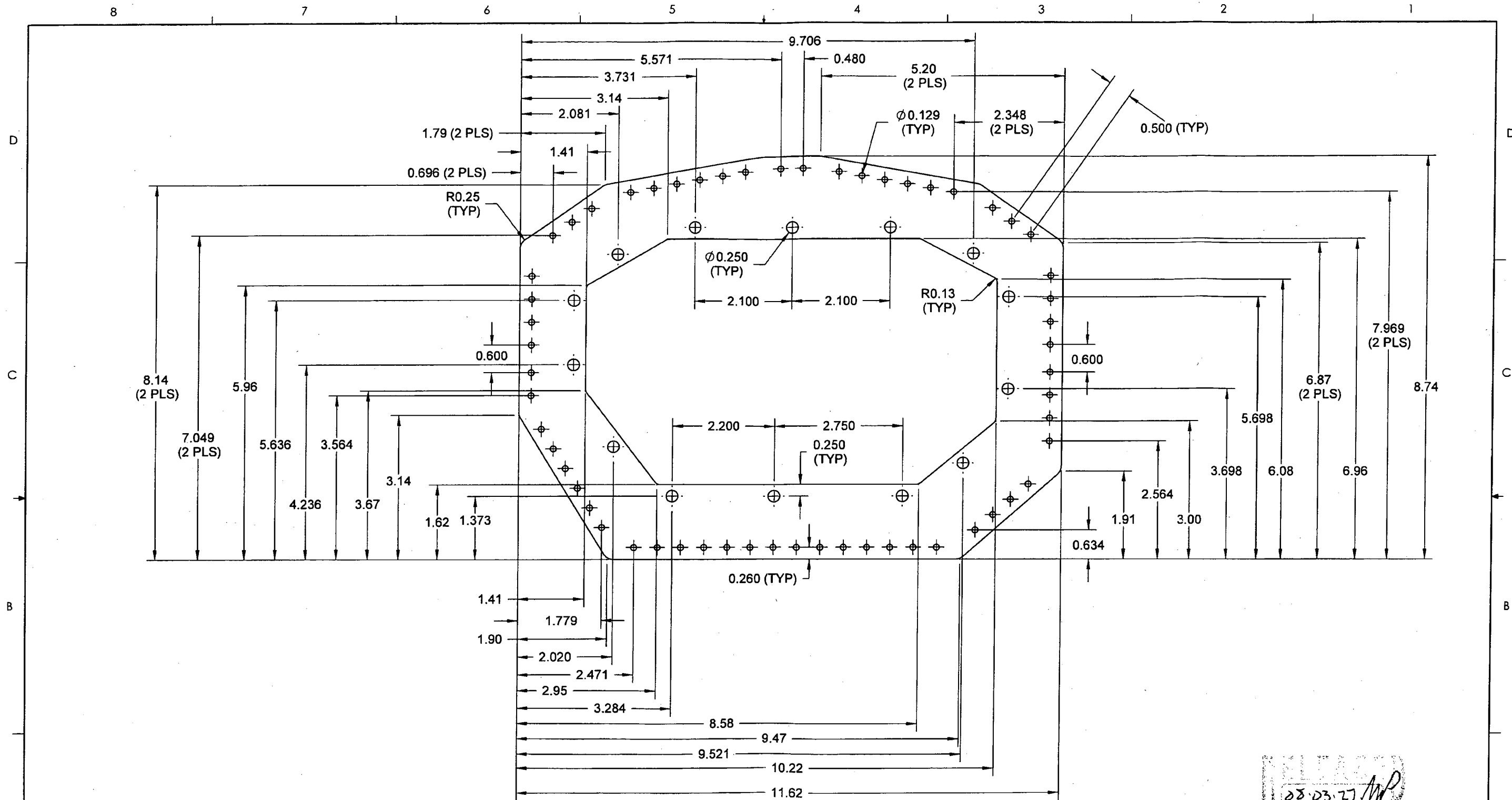
D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	UE	D3651	SHEET 7 OF 9
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NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.2 lb

D3651-11 GASKET

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 8 OF 9
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8 7 6 5 4 3 2 1

D

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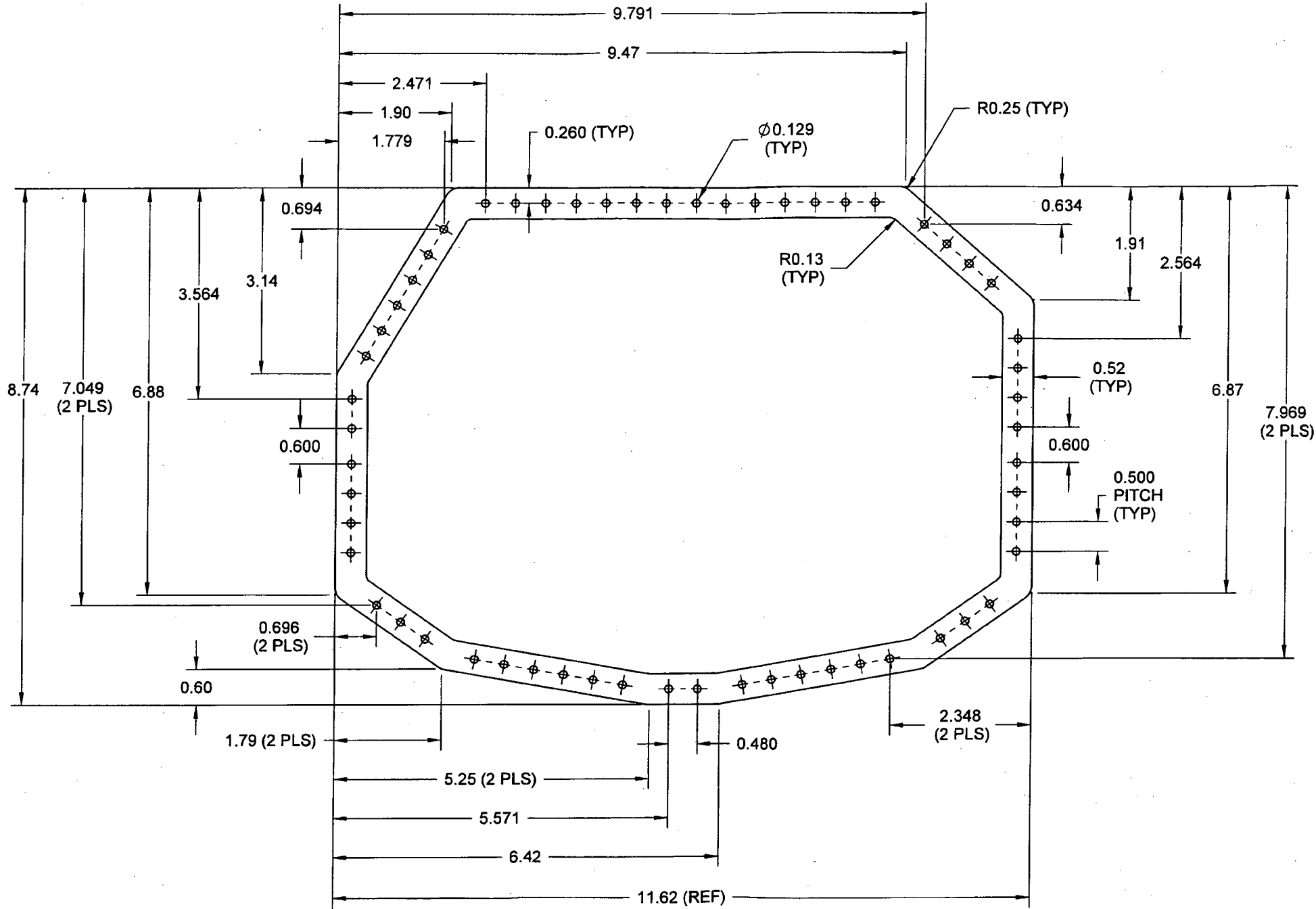
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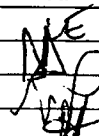


D3651-13 OUTSIDE DOUBLER



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	UNCON
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